

1023
11/11/10

Work Order ID 55191

January 11, 2010 12:37:59 PM



Page 1

Item ID: D3947-4

Accept



Setup Start



Revision ID:

Item Name: Panel, Lower RH Post

Stop



Start Date: 1/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

PL

Date: 10-1-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr	Revision Nbr
D3947	A

100



HAND FINISHING THERMOFORMING

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Cut Blanks to fit frame size

PL 10/11/13 (X)

110



THERMOFORMING MACHINE

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-up

2-Pre-heat tool

3-Thermoform as per Dwg. D3947-4 and Folio FTA 047 using tool DT9484

Dwg. Rev. A

Folio Rev. B

PL 10/11/13 (X)

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Customer:

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC2- Inspect parts off machine FAI/FAIB

0.00

WT 10/01/13 (X1)

QC

Memo

0.00

Quality Control

Visually inspect for proper formation of each part

130



QC8- Inspect parts - second check

0.00

SR 10/01/18 (X1)

QC

Memo

0.00

Quality Control

140



HAND FINISHING THERMOFORMING

0.00

BD 10/01/18 (X1)

Thermoform

Memo

0.00

Thermoforming Machine

Trim to Finished Dimensions as per dwg D3946-1

Work Order ID 55191

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Item ID: D3947-4

Accept



Setup Start



Revision ID:

Item Name: Panel, Lower RH Post

Stop



Start Date: 1/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC2- Inspect parts off machine FAI/FAIB

0.00

DL 10/01/18 (1)

QC

Quality Control

Memo

0.00

Check dimensions to ensure conformity to drawing tolerances.

160



QC5- Inspect part completeness to step on W/O

0.00

→ 510/01/18

QC

Quality Control

Memo

0.00

(K)

170



Identify as per dwg & Stock Location:

Hai Sun

0.00

Packaging

Packaging

Memo

0.00

10-1-18 (2)

Work Order ID 55191

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Item ID: D3947-4

Accept



Setup Start



Revision ID:

Item Name: Panel, Lower RH Post

Stop



Start Date: 1/11/10 Start Qty: 1.00



Cust Item ID:

Required Date: 1/15/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

180



QC21- Final Inspection - Work Order Release

QC

Quality Control

Memo

0.00

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

1/11/10
MF 10-1-18

00700JAN

Picklist Print

January 11, 2010 12:37:57 PM

Page 1

Work Order ID: 55191



Parent Item: D3947-4



Parent Item Name: Panel, Lower RH Post

Start Date: 1/11/10

Required Date: 1/15/10

Comments: IPP RevA: New issue DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MLEXS.093-F6006-07		Purchased	No			100	sf	749.8927	3.6253			

GE PLASTICS LEXAN SHEET

Warehouse

Location

Main Warehouse

MAT	749.8926526	
107574	16.62	
111973	190.526053	
112176	542.7466	1 @ 6.666

Loc Qty

Loc Code

~~3.444~~ sq 41
3.444

Wk 10/01/13 ~~xx~~

DART AEROSPACE LTD	Work Order:	5591
Description: Panel, Lower RH	Part Number:	D3947-4
Inspection Dwg: D3947 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than "	/			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:

JK

Date:

10/01/13

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.5	Min	0.683 "	✓			
1.6	Min	1.6 "	✓			
0.050	Min	0.058 "	✓			
0.065	Min	0.065 "	✓			
22.5	REF	23 "	✓			
10.8	REF	11 "	✓			

Measured by:

JK

Date:

10/01/14

Audited by:

BB

Date:

10/01/14

Prototype Approval:

N/A

Date:

N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	JK







